Date: Monday, 02/03/2009 11:24:02 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: MOUNTING BRACKET
Job Number	: 46176		
Estimate Number	: 12473		
P.O. Number	:	**Part Number**	: D3246041
This Issue	: 02/03/2009 **S.O. No.** :	**Drawing Number**	: D3246 REV A1
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: A1
Previous Run	: 43636	**Material**	:
Written By	:	**Due Date**	: 20/03/2009 **Qty:** 4 **Um:** Each
Checked & Approved By	: JWD 09.03.02		
Comment	: Est Rev:A New Issue 06-06-22 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet

Comment: Qty.: 0.3252 sf(s)/Unit Total : 1.3007 sf(s)
2024-T3 .050 sheet
Material: 2024-T3 (QQ-A-250/4) 0.050" thick
(M2024T3S.050)
Identify for D3246-1 Batch: 107711
ml 09 04 03 (4)

Seq. #:	Machine Or Operation:	Description :
2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg Dsi9279
Dwg Rev: A1
Prog Rev: A1

2-Deburr if necessary
ml 09 04 03 (4)

Seq. #:	Machine Or Operation:	Description :
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 04 03 (4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Seq. #:	Machine Or Operation:	Description :
4.0	QC8	SECOND CHECK

Comment: SECOND CHECK
S 09/04/03 (x4)

Seq. #:	Machine Or Operation:	Description :
5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
Deburr
Form as per Dwg D3246
C'sink as per Dwg D3246
SB 09/04/15 (4)
EB 09/04/07 (4)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:24:02 AM
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Job Number: 46176 **Part Number:** D3246041

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP S 09/04/15 (x4)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 Mf 09-04-15 (x4)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 09/04/15 (4)

9.0	MS20426AD33	Rivet

Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Rivet
Pick:

Qty	Part Number	Description	Batch
8	MS20426AD3-3	Rivet	M17681

09/04/16

10.0	MS21059L3	Nut Plate

Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Nut Plate
Pick:

Qty	Part Number	Description	Batch
4	MS21059L3	Nut Plate	M107394

Identify as D3246-041 09/04/16

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Install Nut Plates as per Dwg D3246 09/04/16 (4)

12.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP S 09/04/16 (x4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:24:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** MOUNTING BRACKET

Job Number: 46176 **Part Number:** D3246041

Job Number:

Seq. #:	Machine Or Operation:	Description :	
13.0	PACKAGING 1	PACKAGING RESOURCE #1	(4k)
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 19	9/11/16	SO
14.0	QC21	FINAL INSPECTION/W/O RELEASE	09/04/16
	Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion

MF
09-04-16

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	4674
Description: Mounting Bracket	**Part Number:**	**D3246-1**
Inspection Dwg: D3246 **Rev:** A1		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.100	√		vern	
Ø0.250	+0.005/-0.001	0.250	√		vern	
11.260	+/-0.010	11.261	√		vern	
6.754	+/-0.010	6.750	√		vern	
5.677	+/-0.010	5.677	√		vern	
2.668	+/-0.010	2.668	√		vern	
3.467	+/-0.010	3.469	√		vern	
2.750	+/-0.010	2.750	√		vern	
2.370	+/-0.010	2.362	√		vern	
0.472	+/-0.010	0.472	√		vern	
0.359	+/-0.010	0.359	√		vern	
0.300	+/-0.010	0.300	√		vern	
0.301	+/-0.010	0.301	√		vern	

Measured by:	M.M	Audited by:	[signature]	Prototype Approval:	N/A
Date:	09.04.03	Date:	09/04/03	Date:	N/A

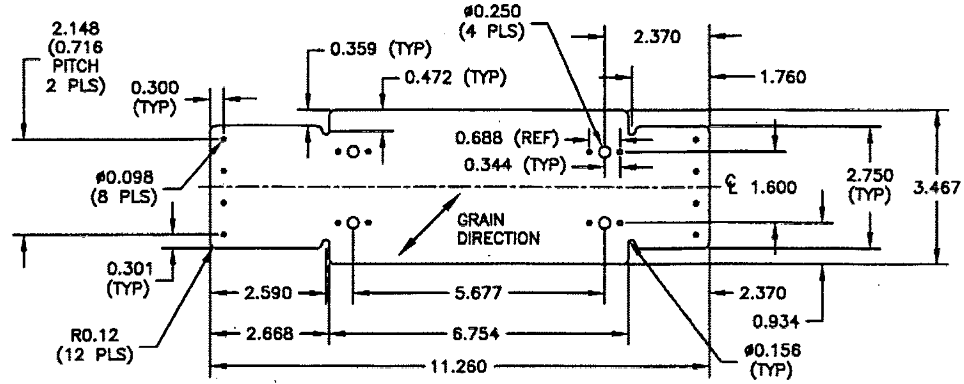
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3246-041	KJ/EC/DD [signature]	[signature]

DART

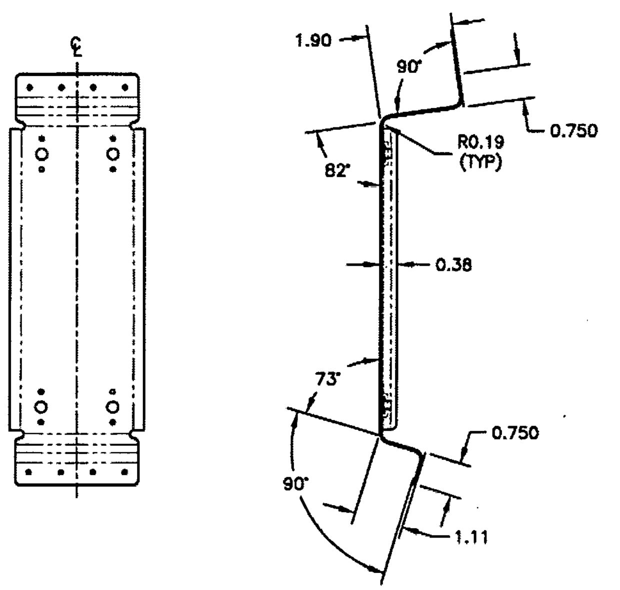
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3246 REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET SCALE 1:4
A	04.04.21	NEW ISSUE
A1	04.06.16	CHANGE RIVET; ADDED C'SINK

QA COPY ISSUED

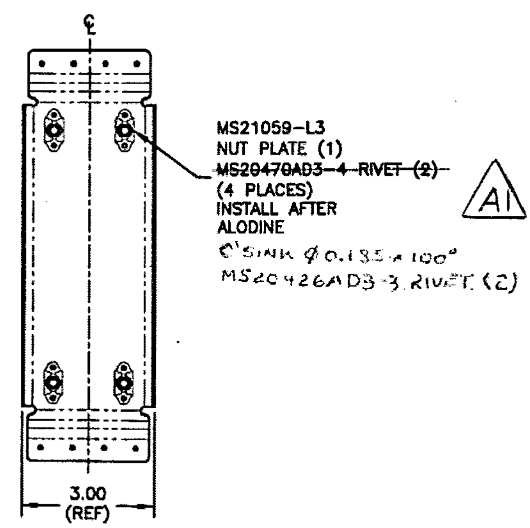
RELEASED 04.05.07



D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46176

NOTES:
1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010